



Dart Aerospace Ltd.
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K6A 1K7
Canada

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split

5204255

D2563

Job Sheet 203294-A



Part No: D2563

Job Qty: 4 pcs

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/2/20

Job Tracking No:

Due Date: 1/3/20

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG-REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
180	Powdercoat - 1 White GI(A)-B4B	4 pcs	1/3/20	1/3/20	0.00	0.67	Powdercoat - 1 - B4B	<i>BL 12 01-02</i>
							Powdercoat - 2 - B4B	
							Powdercoat - 3 - B4B	
							Powdercoat - 4 - B4B	
190	Handfinish - 3-1- WingWalk-B4B	4 pcs	1/3/20	1/3/20	0.00	1.07	Handfinish - 3 - 1 - B4B	<i>BEB 12-01-02</i>
							Handfinish - 3 - 2 - B4B	
							Handfinish - 3 - 3 - B4B	
							Handfinish - 3 - 4 - B4B	
							Handfinish - 3 - 5 - B4B	
200	QC 3	4 pcs	1/3/20	1/3/20	0.00	0.00	QC 3 - 10	<i>DAS 40</i> <i>JAN 03 2020</i> <i>9-09</i>
							QC 3 - 13	
							QC 3 - 15	
							QC 3 - 17	
							QC 3 - 18	
							QC 3 - 2	
							QC 3 - 28	
							QC 3 - 3	
							QC 3 - 30	
							QC 3 - 34	
							QC 3 - 36	
							QC 3 - 41	
							QC 3 - 51	
							QC 3 - 58	
							QC 3 - 59	
							QC 3 - 68	
							QC 3 - 9	
							QC 3 - 40	
							QC 3 - 19	
							QC 3 - 43	
							QC 3 - 24	
							QC 3 - 61	
							QC 3 - 81	
210	Packaging 3-1 - Stock - B4B	4 pcs	1/3/20	1/3/20	0.00	0.00	Packaging 3 - 1 - B4B	

				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	4 pcs	1/3/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 180 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as Descriptions: per QSI 005 4.3 START TIME: _____ 190 - (Wing Walk as per dwg QSI005 4.4 Batch _____) 200 - (QC3- Inspect Part Finish) 210 - (Identify as per dwg & Stock Location: _____) 220 - (QC21- Final Inspection - Work Order Release) Wing walk #5240464					
Job BOM					
Job BOM records could not be found.					
Job Allocations					
Job Allocations could not be found.					

Part Specifications

Specifications could not be found.



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D2563

Job Sheet 203294



Part No: D2563

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Job Created: 11/14/19

Due Date: 11/27/19

Type: SOLD

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	4 pcs	11/27/19	11/27/19	0.00	8.00	Large Fab - 1		SLA
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	4 pcs	11/27/19	11/27/19	0.00	0.00	Large Fab - 12		DAS 43 9-89
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	4 pcs	11/27/19	11/27/19	0.00	0.00	QC 5 - 10		DAS 43 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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https://www.plexonline.com/1c25a56d-e5bf-4d16-9ecc-941b9df9215e/Plexus_Control/Report_Viewer_2.asp?URL=../Part/Job_Sheet.asp&Report=Tru... 2/5

150 Large Fab - Welded Assy-2-B4B	4 pcs	11/27/19	0.00 5.88	QC 7 - 79	
				Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
160 QC 10	4 pcs	11/27/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	DAS
				QC 10 - 50	43
				QC 10 - 58	9-89
				QC 10 - 9	
				QC 10 - 68	
170 QC 5	4 pcs	11/27/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	DAS
				QC 5 - 49	43
				QC 5 - 51	9-89
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
175 Handfinish - 2-1 Pressure-B4B	4 pcs	11/27/19	0.00 1.07	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
180 Powdercoat - 1 White Gl(A)-B4B	4 pcs	11/27/19	0.00 0.67	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
190 Handfinish - 3-1 - WingWalk-B4B	4 pcs	11/27/19	0.00 1.07	Handfinish - 3 - 1 - B4B	
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
200 QC 3	4 pcs	11/27/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	

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					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
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					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
210	Packaging 3-1 - Stock - B4B	4 pcs	11/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
220	QC 21 - SA	4 pcs	11/27/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 100 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Deburr ends Descriptions: 3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind						
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- 110 - (QC9- Inspect visual per QSI004- Fusion Welds)
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Chemical Conversion Coat per QSI005 4.1)
 140 - (QC7-Inspect Chemical Conversion Coat)
 150 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind
 160 - (QC10- Inspect visual per QSI004- ground welds)
 170 - (QC5- Inspect part completeness to step on W/O)
 175 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Touch up Alodine as per QSI005
 180 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: 8:05 N.T. 320° FINISH: 9:05 MA188
 190 - (Wing Walk as per dwg QSI005 4.4 Batch _____)
 200 - (QC3- Inspect Part Finish)
 210 - (Identify as per dwg & Stock Location: _____)
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5081118
D2561	Lug	8 pcs (2 ea)	100-Large Fab - Welded Assy-1	5238075
D2564	Mounting Angle	8 pcs (2 ea)	100-Large Fab - Welded Assy-1	5279162
D2673-34	End Plate	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5210765
D2673-34	End Plate	4 pcs (1 ea)	150-Large Fab - Welded Assy-2- B4B	5210765

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2244-116	4	109	0
	D2561	8	12	0
	D2564	8	35	0
	D2673-34	4	73	0
150-Large Fab - Welded Assy-2- B4B	D2673-34	4	73	0

Part Specifications

Specifications could not be found.

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100- 0 13353 ✓

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			



Container No: S244255



Part: D2563

Job No: 203294-A

Serial No/Batch: S241196

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 01/02/20